

Ship Nov. 6

Work Order ID 108953

October-30-13 10:03:09 AM

108953

Page 1

Item ID: D3868-5

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Spacer

Stop

NS2

Start Date: 10/30/13 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 11/04/13 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals:	Process Plan:	<u>W</u>	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	D3868 Rev A G/B-11.01	0.00							
100	FLOW WATER JET	0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3868 Dwg Rev: A A Prog Rev: A A 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	Memo	0.00							
QC									
Quality Control									
120	QC8- Inspect parts - second check	0.00	DAS						
120	Memo	0.00	27						
QC			9-89						
Quality Control									
			13.10.31						

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NS1

Stop

NS2**Item ID:** D3868-5**Revision ID:****Item Name:** Spacer**Start Date:** 10/30/13 **Start Qty:** 10.00***10*****Cust Item ID:****Required Date:** 11/04/13 **Req'd Qty:** 10.00***10*****Customer:****Reference:****Approvals:** Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab Memo 1- c'sink holes as per dwg D3868 2- deburr	0.00				<i>10X</i>			<i>13/031</i>
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 27 9-89			<i>10</i>			<i>DAS 36 9-89</i>
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>10</i>	<i>10/13-661</i>		

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NS1

Revision ID:

Item Name: Spacer

Stop

NS2Start Date: 10/30/13 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 11/04/13 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC	QC3- Inspect Part Finish	0.00							DAS 36 9-89
	Memo	0.00							13/10/01
Quality Control									

170 *170* Packaging	Identify as per dwg & Stock Location	(4x) STC68	0.00	6X 6A	0.00	10X	DAS 28 9-89	13-11-1
Packaging	Memo							

180 *180* QC	QC21- Final Inspection - Work Order Release	0.00	MLO	13-11-04
Quality Control	Memo	0.00		

u (3.10.06)

Picklist Print

October-30-13 11:25:57 AM

Page 1

Work Order ID: 108953

Parent Item: D3868-5

Parent Item Name: Spacer

Start Date: 10/30/13

Required Date: 11/04/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 09-01-19 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No				sf	403.6000		0.1		A 13:10:30	

Location	Loc Qty	Loc Code
MAT021	403.6	
m126350	211.6	
m126981	192	

126350 → 0.1

DART AEROSPACE LTD	Work Order:	108453
Description: Spacer	Part Number:	D3868-1
Inspection Dwg: D3868 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

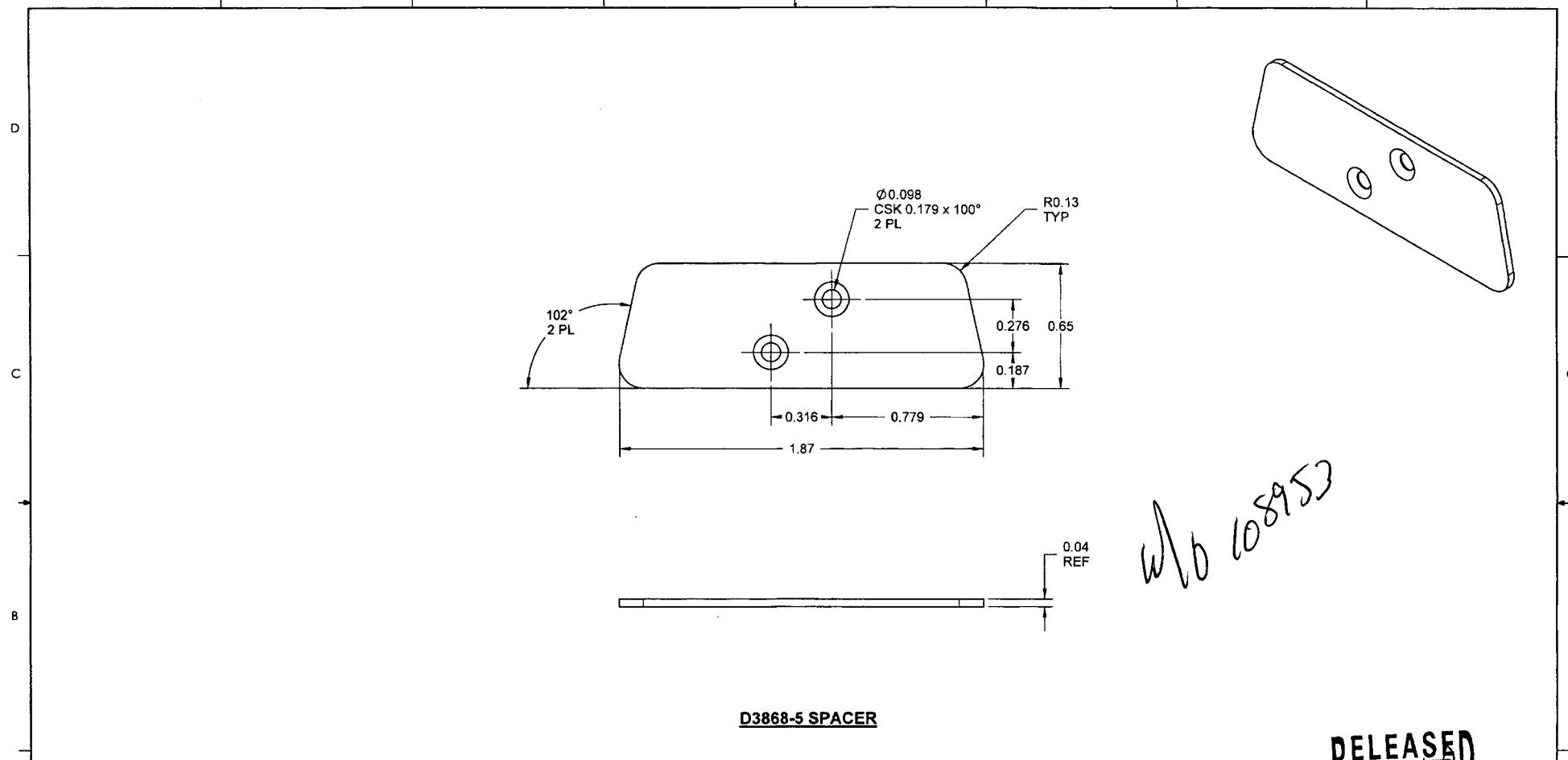
X First Article | Prototype

DAS

Measured by:	<i>Jm</i>	Audited by:	<i>27</i> 9-89	Prototype Approval:	N/A
Date:	<i>13-10-31</i>	Date:	<i>13/10/31</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.02	New Issue	KJ	

8 7 6 5 4 3 2 1



A
NOTES:
 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: LESS THAN 0.01 Lbs

8 7 6 5 4 3 2 1

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>		
MFG. APPR.	<i>AS</i>	DRAWING NO.	REV. A
APPROVED	<i>AS</i>	D3868	SHEET 3 OF 3
DE APPR.	<i>AS</i>	TITLE	SCALE
DATE	09.01.13	SPACER	NTS

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